

Work Order ID 81406

81406

Page 1

March-14-12 7:49:34 AM

Item ID: D3912-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Eyebolt Receiver Assembly 3
 Start Date: 13/03/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/14 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3912	B

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG								
	2- Install helical, spring plunger and spring pin lanyard assy as per dwg								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

Scal/3/12

12/03/14 (5)

12/03/14 (3)

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>507</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/4/12

12-03-30

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Picklist Print

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Page 1

Work Order ID: 81406

81406

Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R		Purchased	No				Each	196.0000		4			
NAS1149C0663R									**				
Washer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST297				196					
					116893			196		3			
D3912-1		Manufactured	No			100	Each	22.0000	1	4			
D3912-1									**				
Eyebolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG091				-12					
					69593			0					
				ST070				21					
					77073			12		3			
					77552			9					
				ST091				13					
					69593			1					
D3912-3		Manufactured	No			100	Each	10.0000	2	8			
D3912-3									**				
Eyebolt Block													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST070				10					
					77554			10		6			

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Work Order ID: 81406

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

81406

D3912-041

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 4.00

Required Qty: 4.00

D3912-5 Manufactured No

100 Each 7.0000 2 8

D3912-5

Eyebolt Plate

**

EP 12/03/29

Location

Loc Qty

Loc Code

ST070

7

76961

7

3

B81458 (3)

D3801-1 Manufactured No

Each 18.0000

D3801-1

Hand Retractable Spring Plunger

**

EP 12/03/29

Location

Loc Qty

Loc Code

GA

6

80996

6

3

ST064

12

68379

2

75178

10

MS20615-4M20 Purchased No

100 Each 122.0000 8 32

MS20615-4M20

RIVET

**

EP 12/03/29

Location

Loc Qty

Loc Code

FP

50

120644

50

GA

72

119546

26

119638

46

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS21209-F615

Purchased

No

Each

64.0000

4

MS21209-F615

**

Heli-Coil

Location

Loc Qty

Loc Code

ST304

18

108170

11

108244

7

ST305

46

108170

0

108244

0

120072

46

EP 12/03/29

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

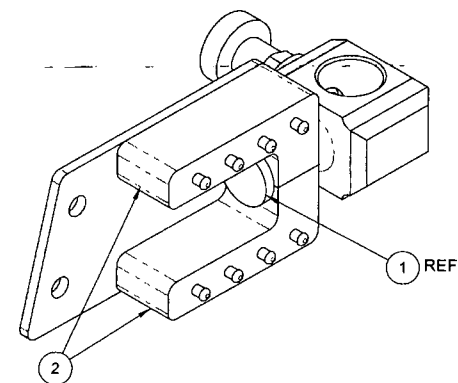
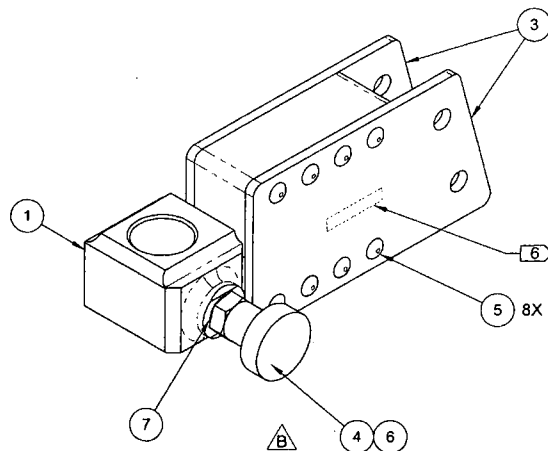
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ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81406 MLC

12/03/14

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	ST		
CHECKED	ST		
MFG. APPR.	ST		
APPROVED	ST		
DE APPR.	ST		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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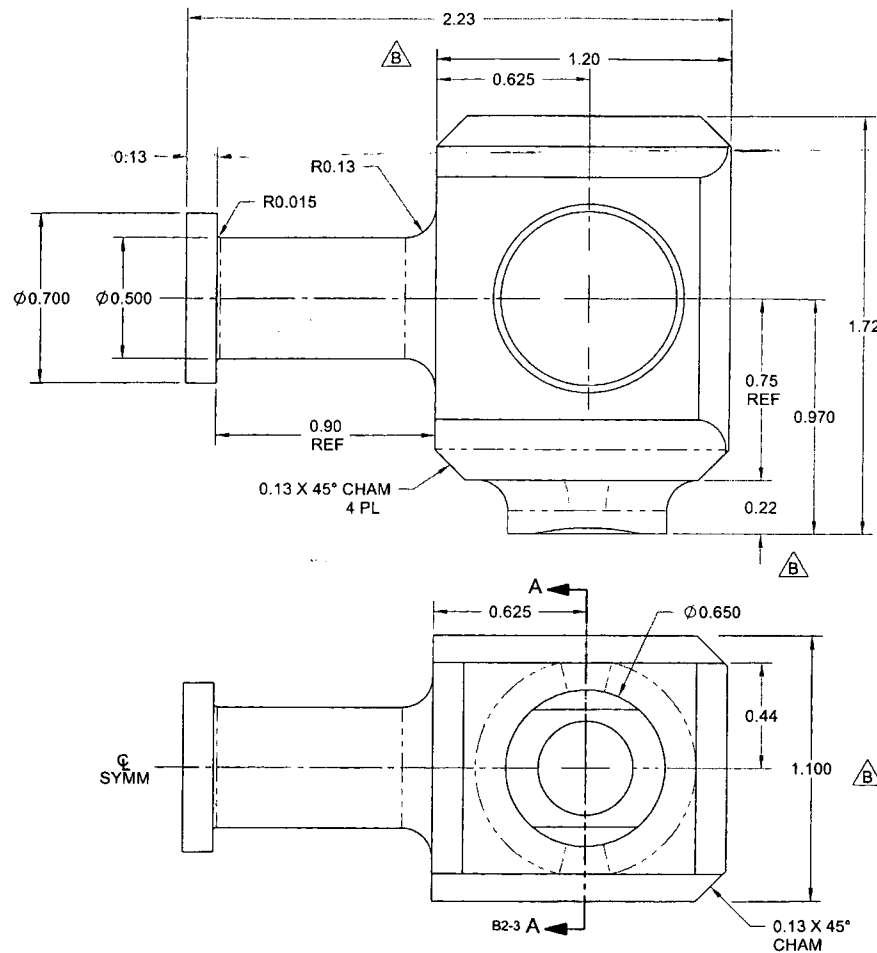
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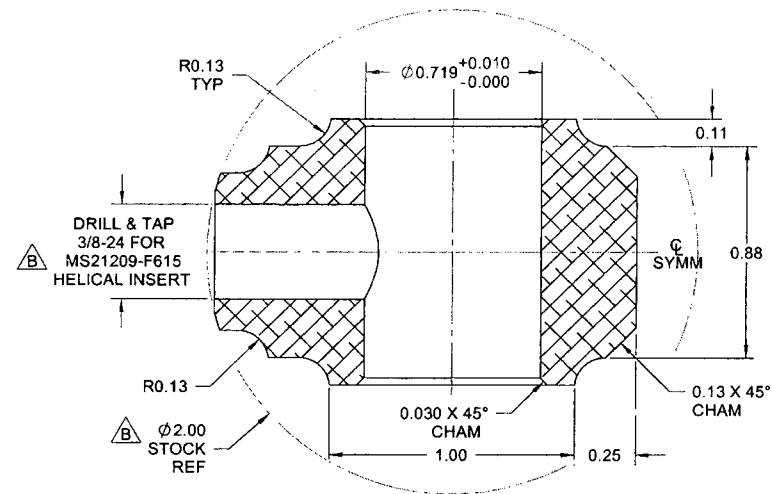
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	ALIS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D3912	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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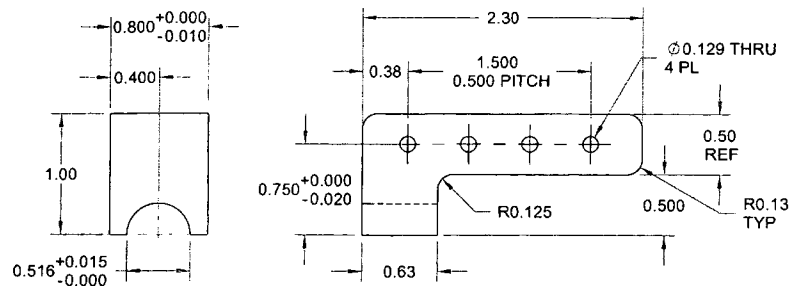
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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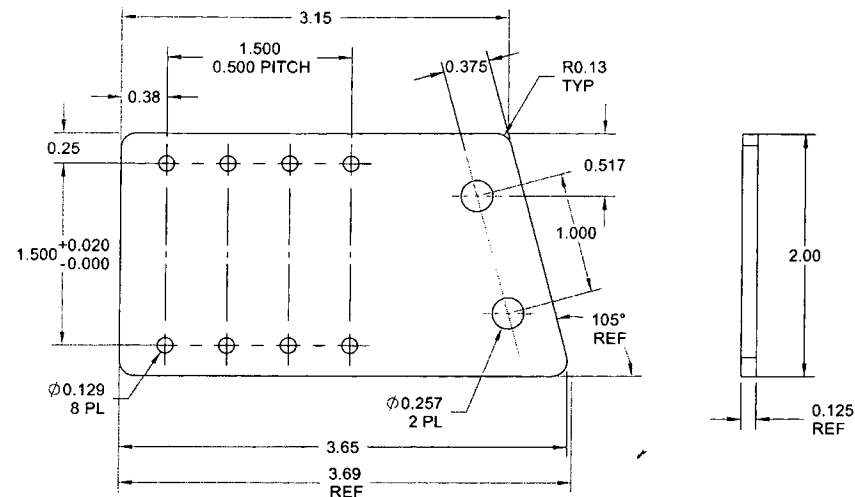
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NOTE: Date & initial all entries

81406



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
mm

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	<i>ALS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>ALS</i>	D3912	SHEET 3 OF 3
APPROVED	<i>ALS</i>	TITLE	SCALE
DE APPR.	<i>ALS</i>	EYEBOLT RECEIVER ASSY	NTS
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